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RBT18510-4
Job Sheet 194324



Part No: RBT18510-4

Job Qty: 6 pcs

Part Name: Stiffener



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/30/19

Job Tracking No:

Due Date: 6/24/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBT18510 Rev.L IPP Rev. A 19.03.12 New issue DP Verify DD

Ship Via:

Bill of Materials

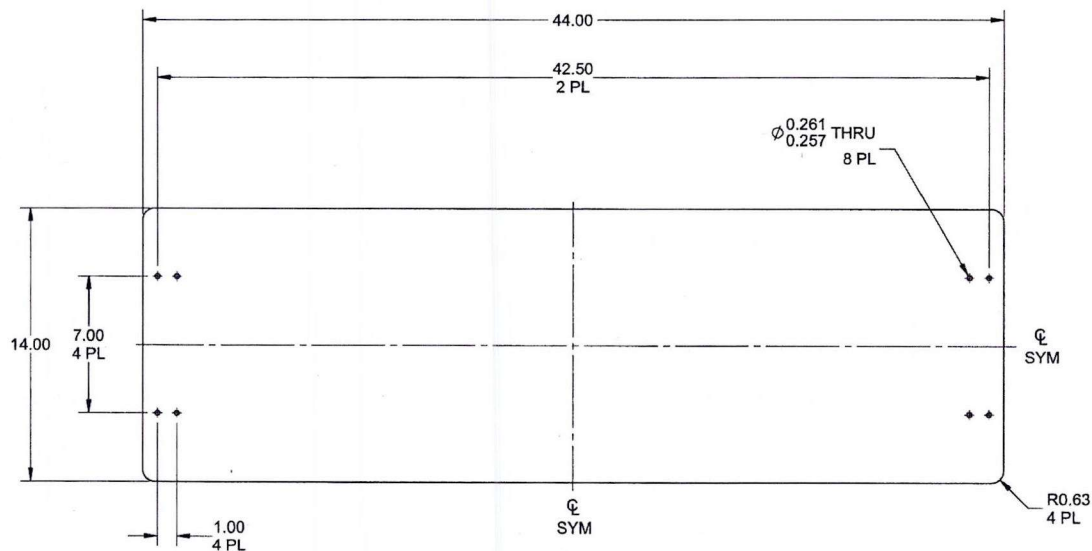
Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Omax - 1	6 pcs	6/24/19	6/24/19	0.00	0.60	Waterjet - Omax		12/19/05/15
110	QC 2	6 pcs	6/24/19	6/24/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		12/19/05/15
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		

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120 QC 8	6 pcs	6/24/19	0.00 0.00	QC 2 - 5				
				QC 2 - 71				
				QC 8 - 12				
				QC 8 - 14				
				QC 8 - 17				
				QC 8 - 20				
				QC 8 - 25				
				QC 8 - 3				
				QC 8 - 32				
				QC 8 - 33				
				QC 8 - 35				
				QC 8 - 39				
				QC 8 - 4				
				QC 8 - 44				
				QC 8 - 45				
				QC 8 - 49				
				QC 8 - 58				
				QC 8 - 8				
				QC 8 - 9				
				QC 8 - 68				
				QC 8 - 67				
				QC 8 - 1 (A)				
				QC 8 - 47				
				QC 8 - 40				
				QC 8 - 52				
				QC 8 - 23				
130 Packaging 3-1 - Stock - B4B	6 pcs	6/24/19	0.00 0.00	Packaging 3 - 1 - B4B				
				Packaging 3 - 2 - B4B				
				Packaging 3 - 3 - B4B				
				Packaging 3 - 4 - B4B				
				Packaging 3 - 5 - B4B				
140 QC 21 - SA	6 pcs	6/24/19	0.00 0.00	QC 21 - SA - 21				
				QC 21 - SA - 70				
Part Op 100 - 1-Cut as per DWG. DWG. Rev: <u>L</u> PROG. Rev: <u>L</u> 2-Deburr if necessary Descriptions: 130 - .					MAY 16 2019 DAS 40 9-89			
MAY 21 2019 DAS 21 9-89								
Job BOM								
Part / Item	Component Name	Quantity	Operation	Container				
M6061T6S.040	6061-T6 .040 Sheet	25.6800 sf (4.28 ea)	100-Waterjet - Omax - 1	MAY 21 2019 DAS 21 9-89				
Job Allocations								
Operation	Component Part	Required	Inventory	Allocated				
100-Waterjet - Omax - 1	M6061T6S.040	26	336	0				
Part Specifications								
Specifications could not be found.								

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RBT18510-4 STIFFENER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 194324 M15
190430

NOTES:

- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. L
MFG. APPR.	DP	RBT18510	SHEET 7 OF 11
APPROVED	<i>W</i>	TITLE	SCALE
DATE	3/7/2019	JET RANGER FIELD KIT	NTS
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

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AEROSPACE

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Container No: S181480



Part: RBT18510-4

Job No: 194324

Serial No/Batch: S181480

Revision: L

Inspector:

Exp Date:

Instructions:

Date: 06/15/19